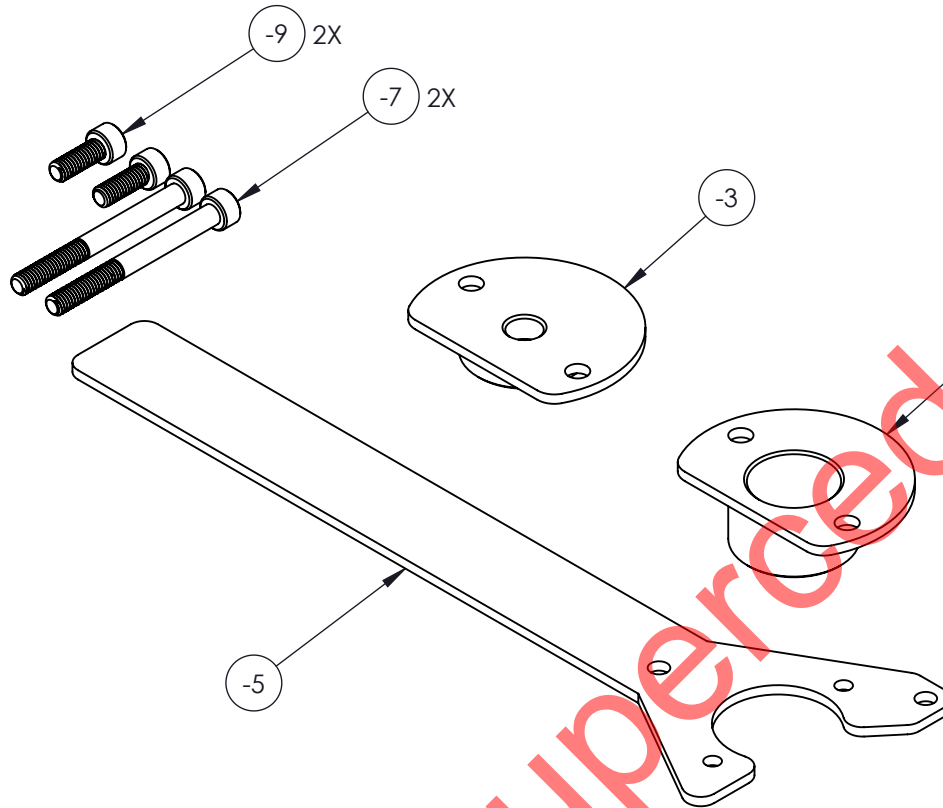


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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION.	8/12/2016	SM	JAG
2	17-0014	-1 DELETED INK STAMP T/N, S/N. ADDED LASER ENGRAVE P/N. -3 DELETED INK STAMP P/N W/BLACK PAINT OPPOSITE SIDE. ADDED LASER ENGRAVE P/N FAR SIDE. -5 ADDED NOTE LASER ENGRAVE T/N, S/N, "MADE IN USA".	1/24/2017	RJC	JAG



**SEE ATTACHED DEVIATION**

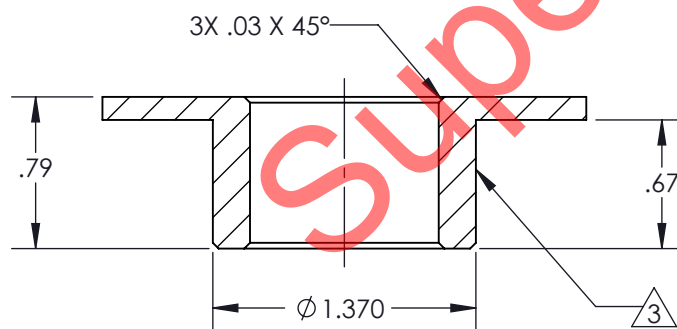
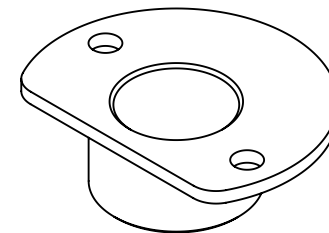
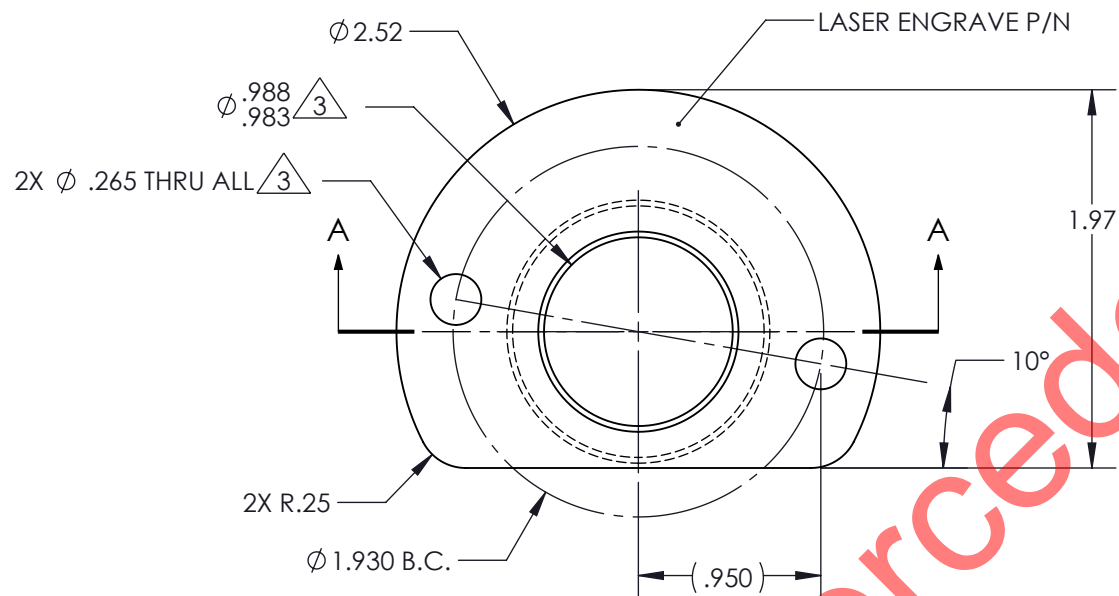
NOTES:  
1. REF. EUROCOPTER T/N: M6232V3021128.  
2. PART OF KIT RBEM632V3021102.

<b>DART AEROSPACE</b>	
TITLE <b>NUT KEY</b>	
DWG NO. <b>RBEM632V3021132</b>	REV <b>2</b>
MAT'L HEAT TREAT FINISH SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125° ✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: <b>MACKOVJAK</b> CHECKED: <b>CLOUGH</b> OPPTS APPR: <b>ANDERSON</b> QA APPR: <b>LINDSAY</b> APPROVED: <b>GILBERT</b>	
USED ON MODEL <b>H175</b>	
SCALE <b>1:2</b>	DATE <b>3/3/2016</b>
SHEET 1 OF 4	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	UNTHREADED PLATE	1018/1020 CR		2
			-3	1	THREADED PLATE	1018/1020 CR		3
			-5	1	HANDLE	4130		4
		B/O	-9	2	SOCKET CAP SCREW	SS	M6 X 1 X 16 MM (MCMASTER-CARR # 91292A135)	1
		B/O	-7	2	SOCKET CAP SCREW	SS	M6 X 1 X 60 MM (MCMASTER-CARR # 91292A413)	1

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	17-0014	-1 DELETED INK STAMP T/N, S/N. ADDED LASER ENGRAVE P/N.	1/24/2017	RJC	JAG



SECTION A-A

(-1)

UNTHREADED PLATE

**SEE ATTACHED DEVIATION**

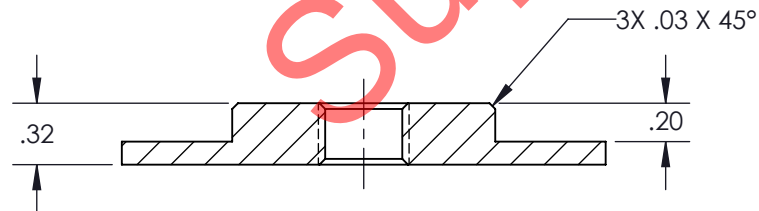
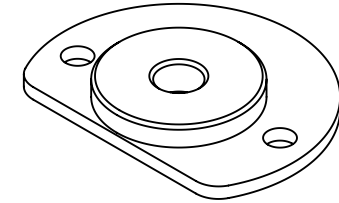
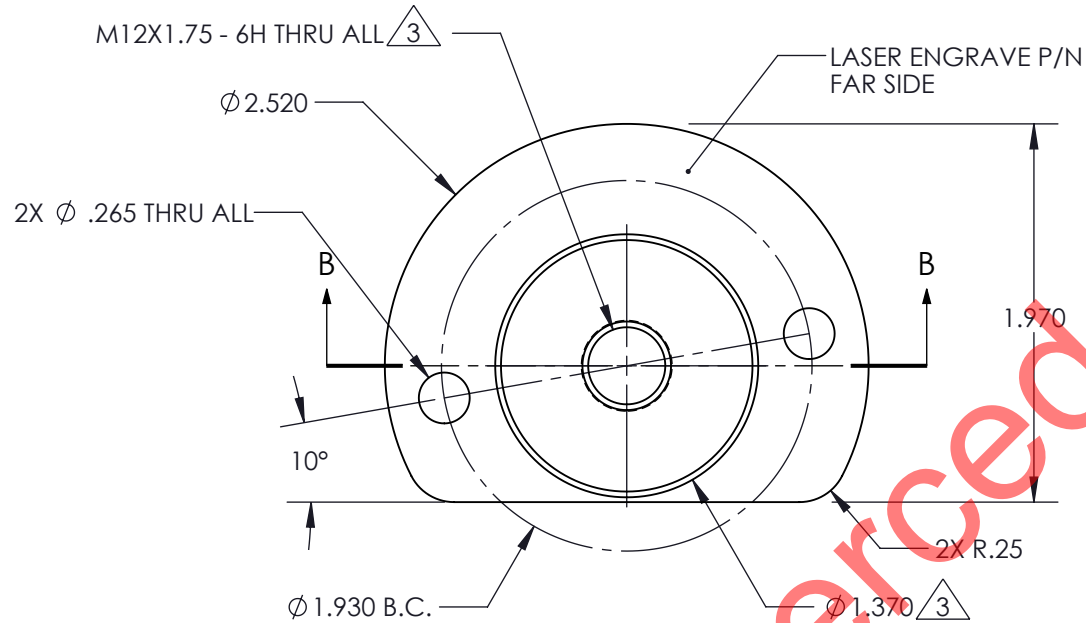
**NOTES:**

1. ZINC PLATE SPEC. ASTM B633 TYPE I.
2. POWDER COAT YELLOW SPEC. FED # 13538.
3. NO POWDER COAT ON SURFACE.

<b>DART AEROSPACE</b>	
TITLE <b>NUT KEY</b>	
DWG NO. <b>RBEM632V3021132-1</b>	REV <b>2</b>
MAT'L 1018/1020 CR HEAT TREAT FINISH SEE NOTES SPEC DRAWN BY: MACKOVJAK CHECKED: CLOUGH OPPTS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX $\pm$ .005 FRACTIONS $\pm$ 1/8 .XX $\pm$ .01 ANGLES $\pm$ .5° .X $\pm$ .1 SURFACES = 125/ $\sqrt{\phantom{x}}$ 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
USED ON MODEL <b>H175</b>	
SCALE <b>1:1</b>	DATE <b>3/3/2016</b>
SHEET 2 OF 4	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	17-0014	-3 DELETED INK STAMP P/N W/BLACK PAINT OPPOSITE SIDE. ADDED LASER ENGRAVE P/N FAR SIDE.	1/24/2017	RJC	JAG



SECTION B-B

(-3)

THREADED PLATE

**SEE ATTACHED DEVIATION**

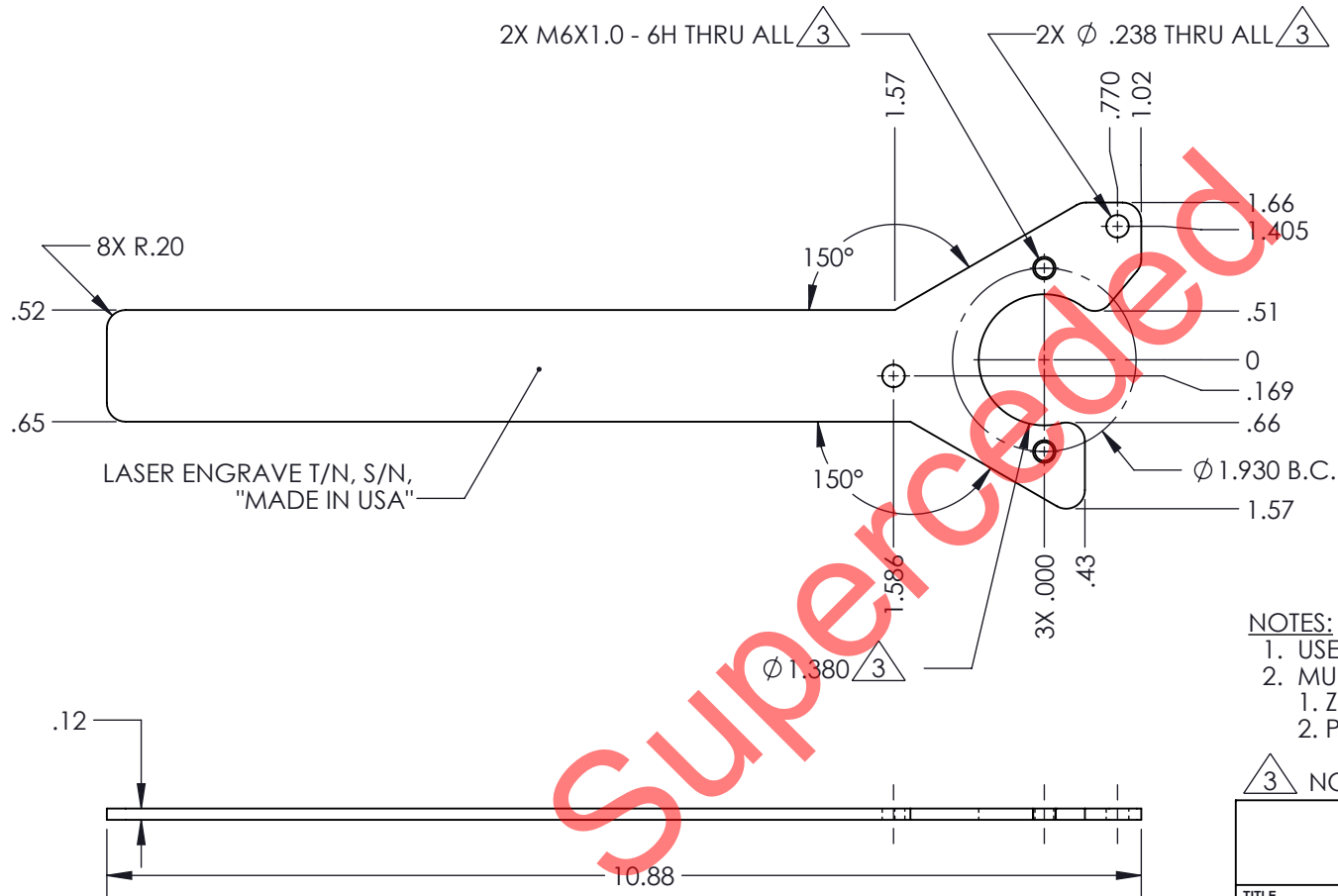
NOTES:

1. ZINC PLATE SPEC. ASTM B633 TYPE I.
2. POWDER COAT YELLOW SPEC. FED # 13538.
3. NO POWDER COAT ON SURFACE.

<b>DART AEROSPACE</b>	
TITLE <b>NUT KEY</b>	
DWG NO. <b>RBEM632V3021132-3</b>	REV <b>2</b>
MAT'L 1018/1020 CR HEAT TREAT FINISH SEE NOTES SPEC DRAWN BY: MACKOVJAK CHECKED: CLOUGH OPPTS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125° 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
USED ON MODEL <b>H175</b>	
SCALE 1:1	DATE 3/3/2016
SHEET 3 OF 4	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	17-0014	-5 ADDED NOTE LASER ENGRAVE T/N, S/N, "MADE IN USA".	1/24/2017	RJC	JAG



**SEE ATTACHED DEVIATION**

**NOTES:**

1. USE CAD DATA FOR MANUFACTURE.
2. MULTIPLE FINISH:
  1. ZINC PLATE SPEC: ASTM B633 TYPE 1 SC2.
  2. POWDER COAT YELLOW SPEC: FED # 13538.

**3** NO POWDER COAT ON SURFACE.



TITLE		NUT KEY	
DWG NO.		RBEM632V3021132-5	
REV		2	
MAT'L 4130		UNLESS OTHERWISE SPECIFIED	
HEAT TREAT		DIMENSIONS ARE IN INCHES	
FINISH POWDER COAT YELLOW		.XXX ± .005 FRACTIONS ± 1/8	
SPEC FED #13538		.XX ± .01 ANGLES ± 5°	
DRAWN BY: MACKOVJAK		.X ± .1 SURFACES = 125	
CHECKED: CLOUGH		1. BREAK ALL SHARP EDGES	
OPPS APPR: ANDERSON		.015 x 45° OR .015R	
QA APPR: LINDSAY		2. DIMENSIONAL LIMITS APPLY	
APPROVED: GILBERT		AFTER PLATING	
SCALE 1:2		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DATE 3/3/2016		USED ON MODEL	
		H175	
		SHEET 4 OF 4	

(-5)

HANDLE

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: \_\_\_\_\_

Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. <u>RBEM632V3021132-3 REV2</u>  NCR No. _____		<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>		<b>AGAINST DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Cross tube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </div> </div>							
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval  OCT 17/18				
<b>Description Work Order Deviation</b>				<b>Disposition</b>			<b>Completed By</b>				
2X .265 DIA HOLE THRU ALL MISSING MASKING DETAIL NOTE 3 TO ENSURE HOLES ARE NOT PAINTED				- This deviation is acceptable.  - The fit, form and function of the part will be as originally intended.			Lead hand / Supervisor Approval Verification				
							QC / QA Coordinator Approval				
<b>Root Cause</b>				<b>FAULT CATEGORY</b>							
Environment	<input type="checkbox"/>	No Re-verification	<input type="checkbox"/>	Pressure/Forced	<input type="checkbox"/>	Temperature/Cure	<input type="checkbox"/>	Power Loss/Surge	<input type="checkbox"/>	Positioned Wrong	<input type="checkbox"/>
Design	<input checked="" type="checkbox"/>	Operator	<input type="checkbox"/>	Bending	<input type="checkbox"/>	Set-up	<input type="checkbox"/>	Folio/Program	<input type="checkbox"/>	Outside Dimensions	<input type="checkbox"/>
Doc/Data	<input type="checkbox"/>	Offset/Setup	<input type="checkbox"/>	Centre Not Concentric	<input type="checkbox"/>	BOM/Route	<input type="checkbox"/>	Grain	<input type="checkbox"/>	Over/Under tolerance	<input type="checkbox"/>
Equip/Tooling	<input type="checkbox"/>	Supplier	<input type="checkbox"/>	Cracks	<input type="checkbox"/>	Broken/Damage/Defect	<input type="checkbox"/>	Weld	<input type="checkbox"/>	Part Incorrect	<input type="checkbox"/>
Handling/Pre	<input type="checkbox"/>	Training	<input type="checkbox"/>	Crimp/Kink/Ripple/Wave	<input type="checkbox"/>	Inspection Incomplete/Unqualified	<input type="checkbox"/>	Wrong Stock Pulled	<input type="checkbox"/>	Part Lost/Missing	<input type="checkbox"/>
Material	<input type="checkbox"/>	Use for Testing	<input type="checkbox"/>	Cuffs	<input type="checkbox"/>	Contamination	<input type="checkbox"/>	Out of Sequence	<input type="checkbox"/>	Part Moved	<input type="checkbox"/>
Internal Transport	<input type="checkbox"/>	Poor Information	<input type="checkbox"/>	Crushing	<input type="checkbox"/>	Countersink	<input type="checkbox"/>	Off-set	<input type="checkbox"/>	Drawing	<input type="checkbox"/>
Tribal Knowledge	<input type="checkbox"/>	Rushing	<input type="checkbox"/>	Heat Treat	<input type="checkbox"/>	Cut Too Short	<input type="checkbox"/>	Mislabeled	<input type="checkbox"/>	Finish	<input type="checkbox"/>
LOA	<input type="checkbox"/>	Product Improvement	<input type="checkbox"/>	Wave/Twist in Tube	<input type="checkbox"/>	Instructions Incomplete/Unclear	<input type="checkbox"/>	Fit/Function	<input type="checkbox"/>	Misread	<input type="checkbox"/>
Substation	<input type="checkbox"/>	Process Improvement	<input type="checkbox"/>	Marks/Chatter	<input type="checkbox"/>	Drill Holes	<input type="checkbox"/>	Misaligned/off center	<input type="checkbox"/>	Turning Sequence	<input type="checkbox"/>
Past Expiry Date	<input type="checkbox"/>	Manufacturing Process	<input type="checkbox"/>	OTHER : _____							
Misidentified	<input type="checkbox"/>	Past Due	<input type="checkbox"/>								